

Date: Thursday, 23/10/2008 10:54:16 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
<b>Job Number</b> : 42891	
<b>Estimate Number</b> : 12933	
<b>P.O. Number</b> :	<b>Part Number</b> : D29392UP
<b>This Issue</b> : 23/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2939 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1/1 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 41728	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/11/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.10.23</u>	
<b>Comment</b> : Est Rev:A New Issue 07-07-04 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length  
 Batch No: B34872 JL 08/11/03

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 5-Deburr JL 08/11/03

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet JL 08/11/03

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET JL 08/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:16 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 42891

Part Number: D29392UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/11/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/11/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-11 (10X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-422

SS 08/11/12 (X10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42891
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2939-2
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.115	.116	.117	.111	.113
B	0.100	0.140		.110	.117	.117	.112	.113
C	0.100	0.140		.115	.115	.112	.114	.114
D	0.210	0.230		.226	.228	.226	.227	.226
E	1.245	1.255		1.248	1.248	1.247	1.248	1.248
F	1.245	1.255		1.247	1.248	1.246	1.246	1.248
G	2.495	2.505		2.499	2.497	2.498	2.498	2.499
H	0.510	0.515		.571	.571	.570	.571	.570
I	1.572	1.582		1.577	1.575	1.575	1.577	1.575
J	2.495	2.505		2.498	2.498	2.499	2.497	2.500
K	0.257	0.262		.258	.258	.258	.258	.260
L	0.312	0.317		.315	.314	.314	.314	.314
M	0.235	0.240		.239	.239	.239	.237	.238
N	0.100	0.140		.110	.110	.109	.110	.109
O	0.540	0.560		.542	.546	.544	.541	.546
P	0.490	0.510		.504	.504	.506	.504	.503
Q	3.715	3.725		3.717	3.716	3.716	3.719	3.719
R	2.720	2.760		2.740	2.745	2.739	2.741	2.743
S	0.240	0.270		.259	.256	.256	.256	.257
T	0.100	0.180		.130	.124	.132	.128	.128
U	1.625	1.635		1.627	1.628	1.628	1.628	1.628
V	1.362	1.372		1.365	1.365	1.366	1.364	1.365
W	0.316	0.321		.319	.320	.320	.320	.320
X	1.250	1.270		1.260	1.261	1.260	1.260	1.260
Y	1.565	1.585		1.574	1.577	1.575	1.574	1.577
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b>	19M	<b>Date:</b>	08/11/08
<b>Audited by:</b>	88	<b>Date:</b>	08/11/11
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 42891	
<b>Description:</b> 206 Saddle, Inboard, Right side				<b>Part Number:</b> D2939-2	
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	X 6	X 7	X 8	X 9	X 10
A	0.100	0.140		.110	.109	.111	.114	.112
B	0.100	0.140		.113	.113	.119	.114	.113
C	0.100	0.140		.113	.112	.124	.126	.127
D	0.210	0.230		.227	.225	.225	.222	.221
E	1.245	1.255		1.248	1.247	1.250	1.250	1.250
F	1.245	1.255		1.246	1.248	1.250	1.250	1.250
G	2.495	2.505		2.497	2.496	2.500	2.500	2.500
H	0.510	0.515		.570	.571	.570	.570	.570
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J	2.495	2.505		2.499	2.500	2.500	2.500	2.500
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L	0.312	0.317		.314	.314	.314	.314	.314
M	*0.235	0.240		.238	.238	.238	.237	.237
N	0.100	0.140		.109	.108	.109	.110	.111
O	0.540	0.560		.546	.544	.546	.545	.544
P	0.490	0.510		.506	.504	.504	.505	.503
Q	3.715	3.725		3.717	3.715	3.713	3.720	3.720
R	2.720	2.760		2.743	2.741	2.741	2.742	2.742
S	0.240	0.270		.256	.255	.255	.254	.254
T	0.100	0.180		.126	.139	.131	.130	.130
U	1.625	1.635		1.629	1.627	1.627	1.630	1.630
V	1.362	1.372		1.366	1.366	1.366	1.367	1.367
W	0.316	0.321		.320	.320	.320	.320	.320
X	1.250	1.270		1.261	1.260	1.259	1.260	1.259
Y	1.565	1.585		1.577	1.576	1.577	1.577	1.577
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> <i>mf / J.L</i>	<b>Date:</b> 08/11/2006
<b>Audited by:</b> <i>SP</i>	<b>Date:</b> 08/11/11
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

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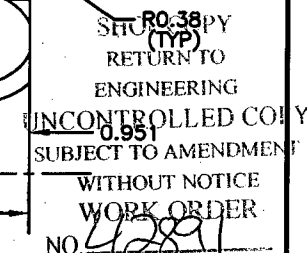
NOTE: Date & initial all entries





Technical drawing of a mechanical part, likely a bracket or arm, showing dimensions and tolerances. The part is oriented vertically with a dashed centerline on the left. Key features include a vertical flange with a fillet (R0.188), a horizontal section with a fillet (R0.50 TYP), and a diagonal section with a fillet (R0.025). Dimensions include 0.510 ± 0.005, 0.500, 0.115, 0.240 ± 0.235, 1.605 ± 0.005, 1.000, 0.140, 0.100, 0.510, and 48.0°. Surface finish symbols (C and B) are present. A note indicates "R0.188 (AROUND POCKET)".

SECTION B-B



DESIGN #	DRAWN BY CB	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2939 REV. SHEET 1 OF
DATE 06.11.09	TITLE SADDLE INSIDE SCALE 2:	

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